

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021877**Date Inspected:** 04-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng /Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Scott Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 10 – Tower Shop

In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 044 located on BK004A1-030. Welder is identified as 057180. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 043 located on BK004A1-030. Welder is identified as 055869. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 044 located on BK004A1-030. Welder is identified as 052075. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 043 located on BK004A1-030. Welder is identified as 040533. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 072 located on BK004A6-025. Welder is identified as 057075. ZPMC Quality Control (QC) is identified as Qui Wen. The

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 073 located on BK004A6-025. Welder is identified as 040302. ZPMC Quality Control (QC) is identified as Qui Wen. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Bay 11 – Tower Shop

In Process Inspection SMAW

This QA Inspector observed the following work in progress: SMAW welding of weld joint 043 located on BK005A-003. Welder is identified as 044541. ZPMC Quality Control (QC) is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 010 located on BK004A1-022. Welder is identified as 205649. ZPMC Quality Control (QC) is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 104 located on BK004C8-026. Welder is identified as 040723. ZPMC Quality Control (QC) is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 016 located on BK004C2-024. Welder is identified as 040723. ZPMC Quality Control (QC) is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA inspector observed ABF Quality Assurance (QA) personnel performing UT of welds on cover for member identified as BK004ASD1-053.

Visual Inspection

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07226

This QA inspector performed VT of approximately 100% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:

BK005B8-004-021, 022, 115, 116, 029, 030, 031, 032, 033, 034, 041, 042, 117, 118, 043, 044

BK005B6-004-158, 021, 115, 116, 029, 030, 031, 032, 033, 034, 041, 042, 117, 118, 043, 162

BK004B8-020-010

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07232

This QA inspector performed VT of approximately 100% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

The members are identified as:

BK005B3-004-051, 052, 013, 014, 019, 020, 140, 141, 142, 143, 073, 074, 079, 080

Magnetic Particle Inspection (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07226

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

BK005B8-004-021, 022, 115, 116, 029, 030, 031, 032, 033, 034, 041, 042, 117, 118, 043, 044

BK005B6-004-158, 021, 115, 116, 029, 030, 031, 032, 033, 034, 041, 042, 117, 118, 043, 162

BK004B8-020-010

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 07232

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

BK005B3-004-051, 052, 013, 014, 019, 020, 140, 141, 142, 143, 073, 074, 079, 080

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang at 15000422372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

Inspected By: Leavitt, Scott

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer